

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003098**Date Inspected:** 26-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM) Quality Assurance (QA) Inspector Edward Leach was present to randomly observe and document the welding and Quality Control (QC) functions performed by ZPMC personnel relative to the fabrication of SAS Superstructure project. While on site, the QA Inspector noted the following work.

OBG-Bay 1

The QA Inspector observed ZPMC has approximately 53 workers performing various functions relative to the fabrication of the OBG Deck Panels. These functions include; closed rib press forming, hole drilling at ends of U-Ribs using a drill template, PJP bevel preparation, closed rib splice FCAW welding, closed rib diaphragm fit-up and FCAW welding, closed rib to deck plate fit-up and tack welding. Also in this bay, the QA Inspector observed the following deck panels located on gantry 1; DP562-001 (idle), DP612-001 (idle) & DP617-001 (tack welded). The following deck panels located on gantry 2 are DP577-001 (idle) & DP195-001 (tack welded). No production welding for the closed U-rib partial joint penetration (PJP) welds was observed on this shift.

Also in bay 1, per ZPMC Ultrasonic Testing (UT) inspection notification (00590) the QA Inspector performed approximately 25% UT verification of the 25% QC UT inspected and accepted welds on the complete joint penetration (CJP) closed U-rib diaphragm plates for DP577-001 & DP587-001. The QA Inspector's visual and UT verification appears to be in general compliance with the contract specification. Please refer to TL-6027 UT report dated 6/26/08 for specific information.

OBG-Bay 7

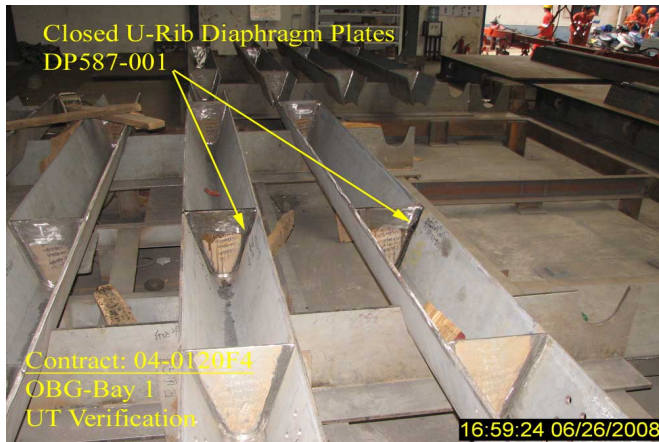
The QA Inspector performed Magnetic Particle Testing (MT) verification for a set of OBG longitudinal diaphragm

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plates that were previously MT inspected & accepted by ZPMC NDT personnel. ZPMC performed MT for approximately 25% of the total accumulative weld length for each assembly. The QA Inspector performed the MT for 10% of the 25% that was accepted by ZPMC. The following longitudinal diaphragm plates were reviewed by QA; LD001-001, LD019-001, LD002-001, LD020-001, LD016-001 & LD017-001. The QA Inspector's visual and MT verification appears to be in general compliance with the contract specification. Please refer to TL-6028 MT report dated 6/26/08 for specific information.

The QA Inspector performed MT verification for a set of OBG floor beams that were previously MT inspected & accepted by ZPMC NDT personnel. ZPMC performed MT for approximately 25% of the total accumulative weld length for each assembly. The QA Inspector performed the MT for 10% of the 25% that was accepted by ZPMC. The following floor beams were reviewed by QA; FB012-010, FB009-006, FB016-011, & FB001-005. The QA Inspector's visual and MT verification appears to be in general compliance with the contract specification. Please refer to TL-6028 MT report dated 6/26/08 for specific information.



Summary of Conversations:

No relevant conversations this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Leach,Ed	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
